



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6505G00831-3G-7
Job Sheet 168797



Part No: RBW6505G00831-3G-7

Job Qty: 1 ea

Part Name: Swivel Plate Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 11/30/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6505G00831-3G Rev2 IPP Rev A New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/29/17	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	1 pcs		11/30/17	0.00	1.00	Large Fab 3		EL
110	QC	1 pcs		11/30/17	0.00	0.00	QC9		CPC
120	Outsource	1 pcs		11/30/17	0.00	0.00	Outsource3		SPLS-01-10
130	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging2		38
140	QC	1 pcs		11/30/17	0.00	0.00	QC6		38
150	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3-2 GA		AT 11/28/17
160	QC21-SA	1 Ea		11/30/17	0.00	0.00	QC21		

Part Op 100 - Weld as per DWG.

Descriptions: 120 - -Issue P/O to Groupe Altech: P/O 38684 -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color: Yellow - Certificate of Conformity is required

13
9-89

DEC 19 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	RBW6505G00831-3G-11	1	0	0	0
	RBW6505G00831-3G-13	2	0	0	0
	RBW6505G00831-3G-15	2	0	0	0
	RBW6505G00831-3G-17	1	0	0	0
	RBW6505G00831-3G-9	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 11/23/17 9:13 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐		Skid-tube ☐	
NCR No. _____		Scrap ☐		Machining ☐	
		Use-as-is ☐		Thermoforming ☐	
		Suspected Unapproved ☐		Large Fab ☐	
Date : _____		Step #: _____		QTY Effective : _____	
Description Work Order Deviation					
Root Cause		FAULT			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure		
Design ☐	☐ Operator	☐ Bending	☐ Set-up		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unq		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unc.		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes		
Past Expiry Date ☐	☐ Manufacturing Process				
Misidentified ☐	☐ Past Due				
		OTHER : _____			

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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART AEROSPACE
S023279

Swivel Plate Weldment

PART NO: RBW6505G00831 - 3G - 7
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/15/17
Job No: 168797

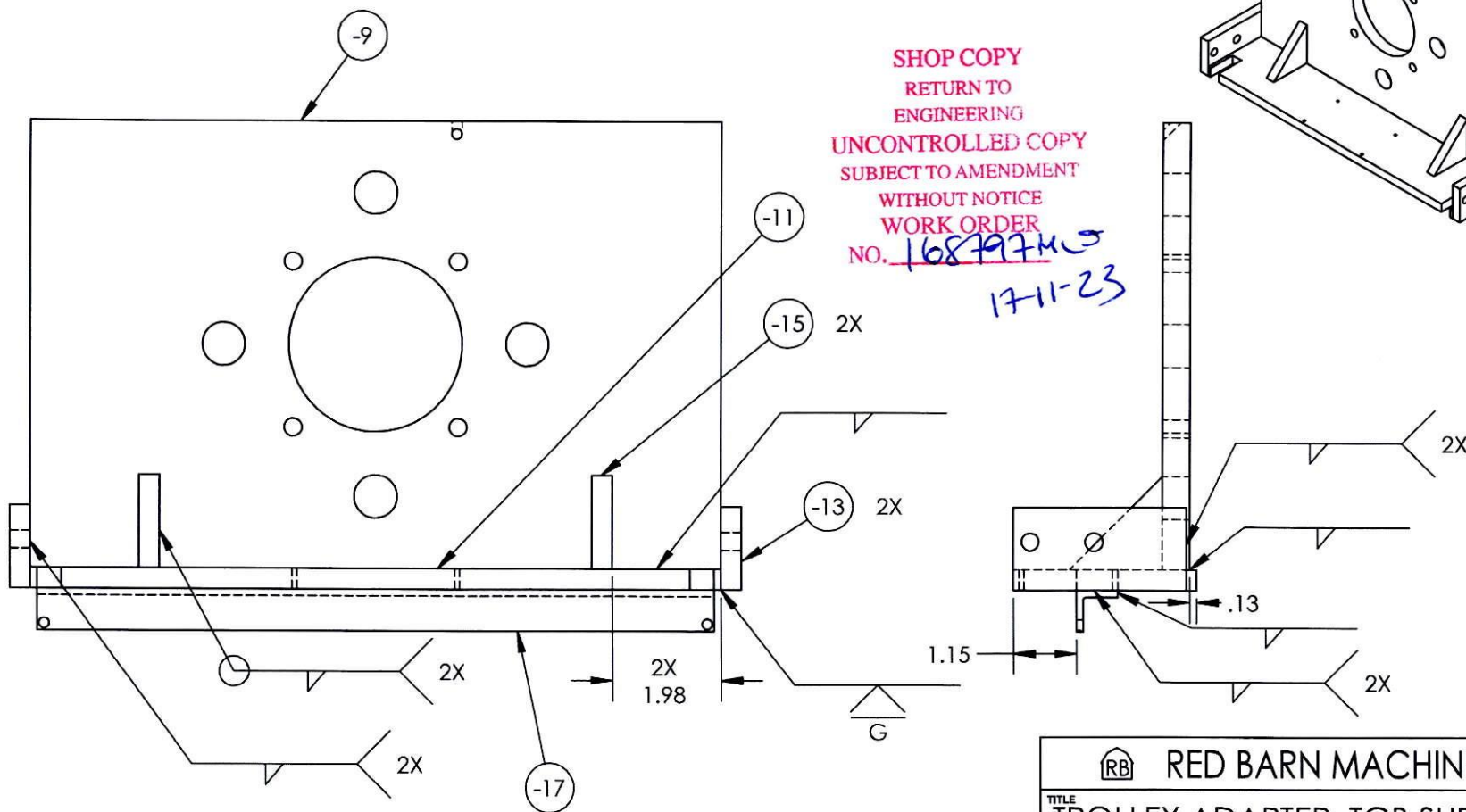
☐ Misaligned/off center ☐ Turning Sequence

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

TEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168797MCS
17-11-23



SWIVEL PLATE WELDMENT

RED BARN MACHINE	
TITLE TROLLEY ADAPTER, TGB SUPPORT	
DWG NO. RBW6505G00831-3G-7	REV 2
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC QQ-P-416F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:3	AW139
DATE 2/6/2012	SHEET 6 OF 16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038684**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038684
PO Date: 12/19/17
Due Date: 1/3/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

E-MAILED

DEC 20 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

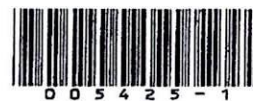
Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	168797	RBW6505G00831-3G-7	Swivel Plate Weldment -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
2	168796	RBW6505G00831-3G-1	Leg Assembly Weldment -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
3	169248	RBW6505G00831-3G-21	Swivel Plate -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
4	169589	RB6796941-201-3	Plug -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/3/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

005425- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.
08-Jan-2018	Ross Montieth		038684

#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6505G00831-3G-7 Rev.	SWIVEL PLATE WELDMENT 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CADMIUM CH	1	1	0	0	0
2	RBW6505G00831-3G-1 Rev.	LEG ASSEMBLY WELDMENT 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CADMIUM CH	1	1	0	0	0
3	RBW6505G00831-3G-21 Rev.	SWIVEL PLATE 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CADMIUM CH	1	1	0	0	0
4	RB6796941-201-3 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
5	647.8510 Rev.	647.8510 PASSIVATE ,MIL-5-5002 TYPE 6	PASSIVATION CH	80	80	0	0	0

SP 18-01-10

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
 Our financial and legal responsibility will not be higher than the amount of invoice.

DART
AEROSPACE
S030919

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Swivel Plate Weldment

PART NO: RBW6505G00831 - 3G - 7
Revision:
Operation: Outsource
Change No:

Mfg Date: 01/10/18

Job No: 168797